

Date: Wednesday, 3/21/2007 1:59:07 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	GASKET		
Job Number	31400					
Estimate Number	12789					
P.O. Number	N/A		Part Number	D35531		
This Issue	3/21/2007	S.O. No.	N/A	Drawing Number	D3553 REV A	
Prsht Rev.	NC			Project Number	N/A	
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision	A	
Previous Run	N/A			Material	N/A	
Written By			Due Date	3/30/2007	Qty:	10
Checked & Approved By	<u>JL</u> 07.03.21		Um:	Each		
Comment	Est Rev:A New Issue 07-03-08 ec					

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
1.0	MNEO60S063	NEOPRENE SHEET 0.063
Comment: Qty.: 0.1103 sf(s)/Unit Total : 1.1025 sf(s) NEOPRENE SHEET 0.063		<i>m103104 ml 07 04 03</i>
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3553 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>		<i>ml 07 04 03</i>
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>ml 07 04 04</i>
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		<i>Jor 04.04.04</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>EJ 07 04 04</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

3/21/07/05

Job Completion



W. A. O. A.

Dart Aerospace Ltd

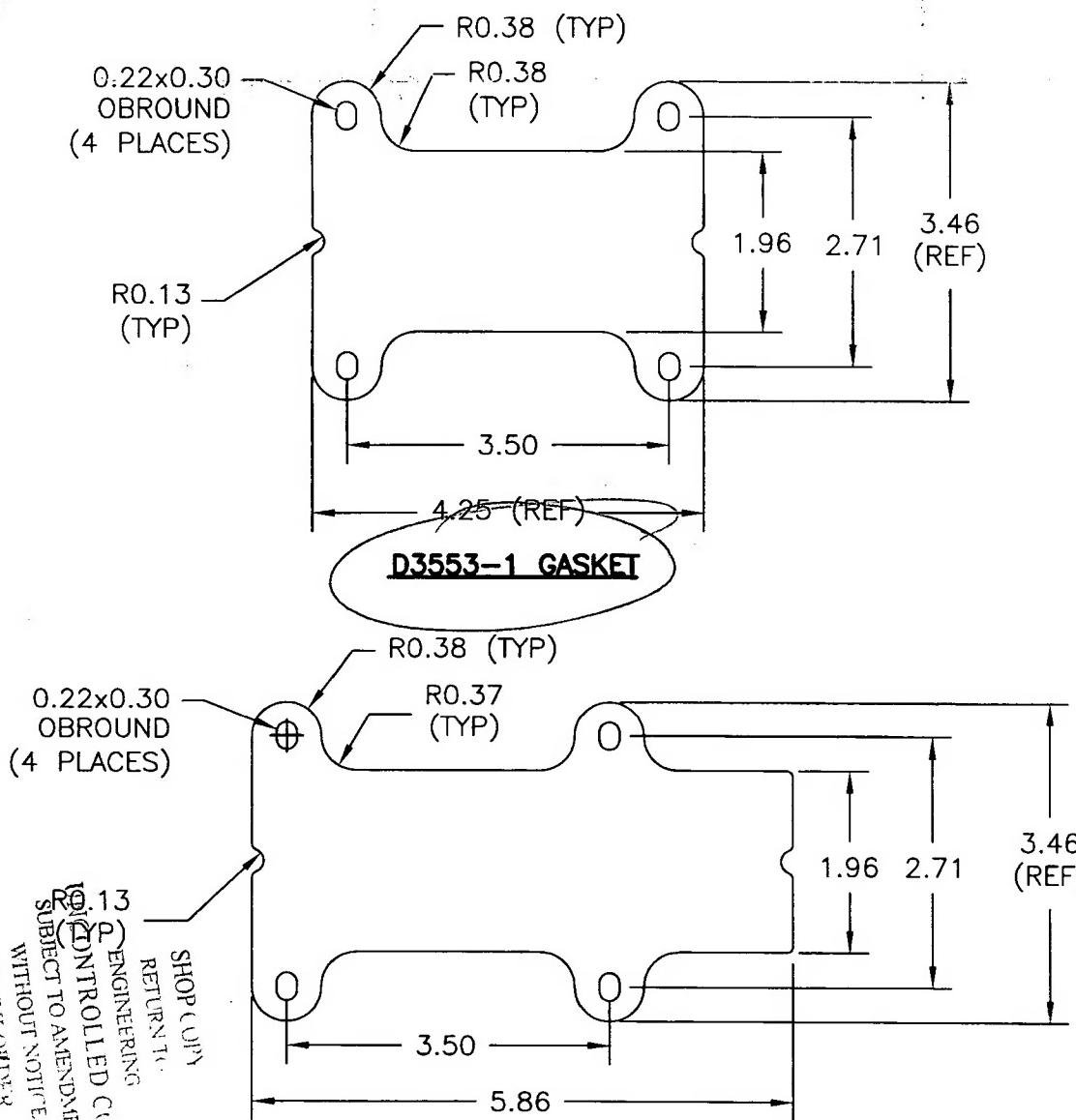
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 31400



D3553-1/-3 GASKET

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED
07 02 28

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3553	REV. A SHEET 1 OF 1	
DATE 07.01.11		TITLE GASKET	SCALE 1:2	
A	07.01.11	NEW ISSUE		

DART AEROSPACE LTD	Work Order:	31400
Description: Gasket	Part Number:	D3553-1
Inspection Dwg: D3553 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.22x0.30	+/- 0.030	0.20x0.30	✓		VERN	
B 3.50	+/- 0.030	3.50	✓		VERN	
C 4.25	+/- 0.030	4.25	✓		VERN	
D 1.96	+/- 0.030	1.96	✓		VERN	
E 2.71	+/- 0.030	2.71	✓		VERN	
F 3.46	+/- 0.030	3.46	✓		VERN	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M. M.
Date:	070404

Audited by:	J
Date:	070404

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

